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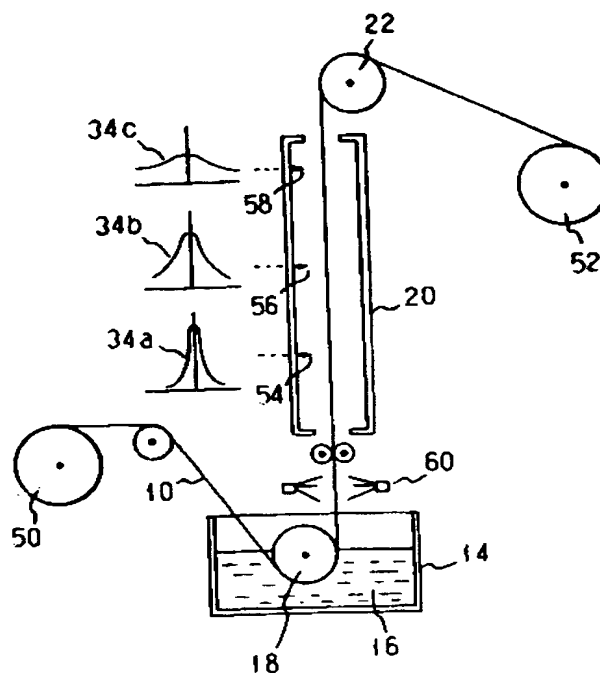
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APPLICANT : NIPPON STEEL CORP;

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INT.CL. : C23C 1/02 G01N 21/47 G01N 33/20

TITLE : METHOD FOR CONTROLLING
ALLOYING OF GALVANIZED STEEL
PLATE



ABSTRACT : PURPOSE: To control the degree of alloying of a plating layer in an adequate range, by providing a device for deciding the degree of alloying from the distribution of reflected light in an alloying chamber for a galvanized steel plate and controlling the moving time of the steel plate from the completion point of alloying up to the outlet of the furnace.

CONSTITUTION: A steel plate 10 supplied from an uncoiling roll 50 is passed through the molten zinc liquid 16 in a plating cell 14 by means of a synchronizing roll 18 and is thereby galvanized, whereafter the steel plate is heated properly in an alloying chamber 20 to alloy zinc and iron, and the galvanized steel plate is taken up on a take-up roll 52 via a deflector roll 22. Devices 54, 56, 58 for deciding alloy by reflected light are provided in said furnace 20 in such a galvanizing device as mentioned above. The alloying does not progress from the half-amplitude level of the distribution curve of reflected light measured by said devices up to the measurement point of the device 54. The alloying is under progression at the point 56 and the end of the alloying can be decided at the point 58. The holding time for the alloying after the end of the alloying is controlled by regulating the temp. of the zinc bath 16, the conveyance speed of the steel plate 1, etc.

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